

# Work Order ID 52573

October 1, 2009 3:35:58 PM



Page 1

Item ID: D3451-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Tube Handle Arm

Start Date: 10/02/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-10-01

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3451

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3451 Dwg Rev: A Prog Rev: A 12-  
Deburr if necessary

IB 9-10-5

17

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-10-5

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

→ 809/10/05

17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D3451-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Tube Handle Arm

Start Date: 10/02/2009 Start Qty: 12.00



Cust Item ID:

Required Date: 10/12/2009 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location:

*EE*  
*can*

0.00



Packaging

Memo

0.00

Packaging

*9/14/5*

*17.54*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*09/10/06*  
*mf 09-10-05*

W/O:		WORK ORDER CHANGES					
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# Picklist Print

October 1, 2009 3:35:58 PM

Page 1

Work Order ID: 52573

Parent Item: D3451-3RevA

Parent Item Name: Tube Handle Arm

Comments:

Start Date: 10/02/2009

Required Date: 10/12/2009

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

100

sf

113.0104

0.9322

1.400



6061-T6 .125 Sheet

B9-10-5

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

113.0104

110062

1.85

111642

19.592

112476

32

112567

59.5684

112.567

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

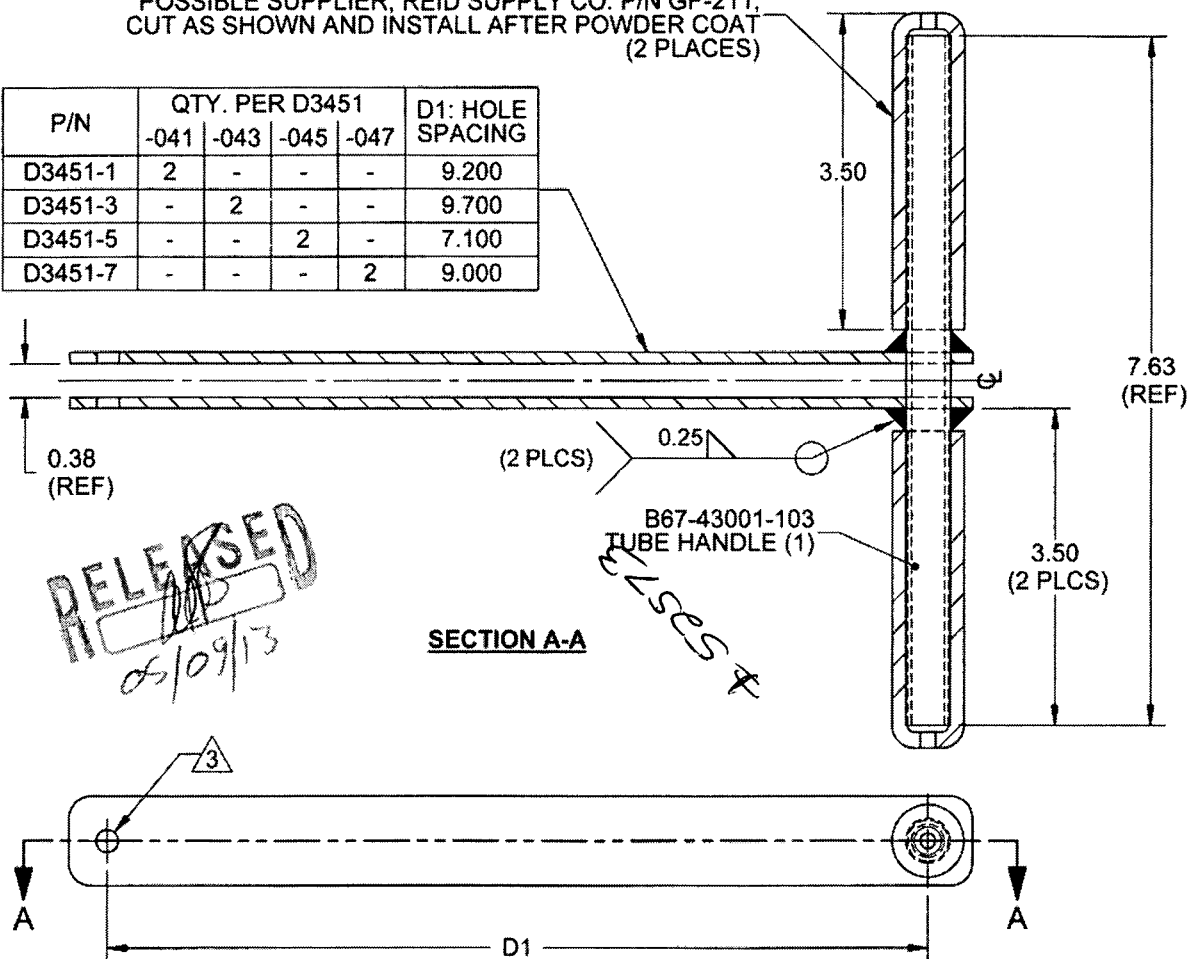


**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3451</b>	REV. A SHEET 1 OF 2
DATE <b>05.08.25</b>		TITLE <b>HANDLE &amp; LOCK-DOWN ASS'Y</b>	SCALE 1:2
A	05.08.25	NEW ISSUE	

0.50" ID x 4.875" LONG BLACK VINYL HANDLE,  
POSSIBLE SUPPLIER, REID SUPPLY CO. P/N GP-211,  
CUT AS SHOWN AND INSTALL AFTER POWDER COAT  
(2 PLACES)

P/N	QTY. PER D3451				D1: HOLE SPACING
	-041	-043	-045	-047	
D3451-1	2	-	-	-	9.200
D3451-3	-	2	-	-	9.700
D3451-5	-	-	2	-	7.100
D3451-7	-	-	-	2	9.000



### **D3451-041/-043/-045/-047 HANDLE & LOCK-DOWN ASS'Y**

**D3451-041 SUPERSEDES PREMIER P/N B67-43001-41**

**D3451-045 SUPERSEDES PREMIER P/N B67-43001-39**

**D3451-047 SUPERSEDES PREMIER P/N B67-43001-55**

#### **NOTES:**

- 1) WELD PER DART QSI 004
- 2) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) MASK BEFORE PAINTING.
- 4) FINISH: POWDER COAT PAINT GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
- 5) PART IS SYMETRICAL ABOUT CENTER LINE.
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

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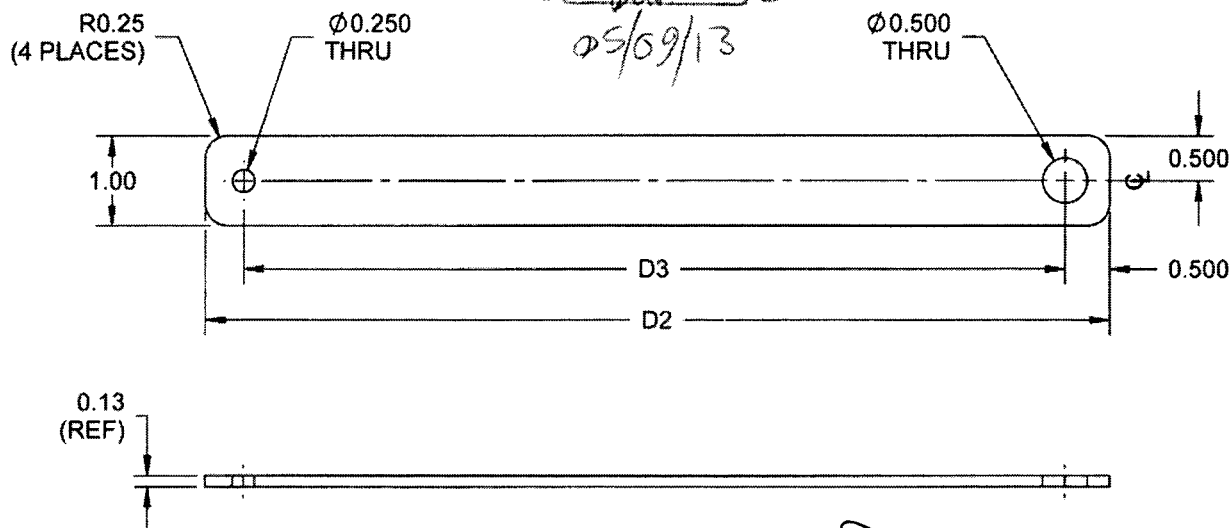
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**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3451</b>	REV. A SHEET 2 OF 2
DATE <b>05.08.25</b>		TITLE <b>HANDLE &amp; LOCK-DOWN ASS'Y</b>	SCALE 1:2

**RELEASED**  
*[Signature]*  
05/09/13

P/N	D2: CUT LENGTH	D3: HOLE SPACING
D3451-1	10.25	9.200
D3451-3	10.63	9.700
D3451-5	8.00	7.100
D3451-7	10.00	9.000

*10.075*

**D3451-1/-3/-5/-7 TUBE HANDLE ARMS****D3451-1 SUPERSEDES PREMIER P/N B67-43001-303****D3451-5 SUPERSEDES PREMIER P/N B67-43001-301****D3451-7 SUPERSEDES PREMIER P/N B67-43001-101****NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B0.125)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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